












Date: Monday, 7/16/2007 2:46:55 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE
Job Number	: 33563		
Estimate Number	: 10366		
P.O. Number	: N/A	Part Number	: D412742013
This Issue	: 7/16/2007 S.O. No. : N/A	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 33556	Material	: N/A
Written By	: <u> </u>	Due Date	: 7/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DSI9336 JLM		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
			
Comment: DOCUMENT CONTROL Photocopy bluefile and create labels per PPP D412-742-013 CHG003			
2.0	33563A	FLOAT SKID ASSEMBLY	
			
Comment: Sub-Component FLOAT SKID ASSEMBLY D412-742-043 B <u>33525 A</u>			
3.0	D2571	Saddle, Fwd, Out	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2571 Saddle Fwd Outside <u>1531647</u> ✓ <u>sd</u>			
4.0	D2572	Saddle, Fwd, In	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2572 Saddle Fwd Inside <u>1531714</u> ✓ <u>sd</u>			
5.0	D2573	Saddle, Aft, Out	
			
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2573 Saddle Aft Outside <u>33042</u> ✓ <u>7/7/24 59</u>			

Date: Monday, 7/16/2007 2:46:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33563

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2574

Saddle, Aft, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2574

Saddle Aft Outside

1531718 ✓

sq

7.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2747

Bolt

1531300 ✓

sq

8.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2876

Saddle Spacer

1531227 ✓

sq

9.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2877

Saddle Spacer

1530055 ✓

sq

10.0

D34031

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 D3403-1

Bushing

1532888 ✓

30
B 33862 8 ✓ 6/17/27

11.0

D34033

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 D3403-3

Bushing

1532889 ✓

7/7/24 50

Date: Monday, 7/16/2007 2:46:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33563

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D3405041

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-041

GHW Lug

1532890 ✓

SP

13.0

D3405043

Lug Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3405-043

GHW Lug

1532891 ✓

SP

14.0

AN4C6A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN4C6A

Bolt

1104936 ✓

SP

15.0

AN4C46A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C46A

Bolt

119529 ✓

SP

16.0

AN4C52A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C52A

Bolt

1100340 ✓

SP

17.0

AN6C12A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN6C12A

Bolt

1104289 ✓

7/2/24 SP

Date: Monday, 7/16/2007 2:46:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33563

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960C416L

WASHER



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 AN960C416L

Washer

M104925 ✓

59

19.0

AN960C616L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C616L

Washer

M10822 ✓

59

20.0

AN960C716L

WASHER



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 AN960C716L

Washer

~~M104925~~
M13542 ✓

59

21.0

MS210434

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

29 MS21043-4Nut

Washer

M104936 ✓

59

22.0

NAS1515H4L

Inventory



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

32 NAS1515H4L

Washer

M104956 ✓

7/7/24 59

Date: Monday, 7/16/2007 2:46:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33563

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

NAS1515H6L

Inventory



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H6L

Washer

1118809 ✓

SP

24.0

NAS1515H7L

Inventory



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H7L

Washer

11100727 ✓

SP

25.0

D3407041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-041

TOW RING

1530394 ✓

SP

26.0

D34173

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3417-3

WASHER

1533519 ✓

SP

27.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

WASHER

1533274 ✓

SP

28.0

AN4C7A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch:

11101427 ✓

7/7/24 SP

Date: Monday, 7/16/2007 2:46:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKIDTUBE

Job Number: 33563

Part Number: D412742013

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



07/08/01



Comment: INSPECT 100% KITS FOR COMPLETENESS

07/08/01

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-013

Location:

REV: D 07/08/02

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/02

Job Completion



33525A

07/08/02

31

Date: Monday, 7/16/2007 2:46:55 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKIDTUBE
Job Number	: 33563		
Estimate Number	: 10366		
P.O. Number	:	Part Number	: D412742013
This Issue	: 7/16/2007 S.O. No. :	Drawing Number	: N/A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: N/A
Previous Run	: 33556	Material	:
Written By	:	Due Date	: 7/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>07.07.17</u>		
Comment	: Est Rev: A 05.10.13 New Issue KJ/JLM Est Rev: B 06-06-08 As per DSI9336 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-742-013 CHG003

07.07.26

2.0

33563A

FLOAT SKID ASSEMBLY



Comment: Sub-Component FLOAT SKID ASSEMBLY
 D412-742-043 B _____

3.0

D2571

Saddle, Fwd, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2571 Saddle Fwd Outside _____

4.0

D2572

Saddle, Fwd, In



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2572 Saddle Fwd Inside _____

5.0

D2573

Saddle, Aft, Out



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

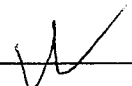
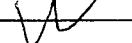
Pick:

Qty Part Number Description Batch

1 D2573 Saddle Aft Outside _____

Date: Tuesday, 02/10/2007 2:16:42 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : K742-013
Job Number : 34974	
Estimate Number : 10804	
P.O. Number : N/A	Part Number : K742 013
This Issue : 02/10/2007 S.O. No. : N/A	Drawing Number : RE-STOCK
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : N/A
Previous Run : 00015	Material : N/A
Written By : 	Due Date : 09/10/2007 Qty: 2 Um: Each
Checked & Approved By : 	
Comment :	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

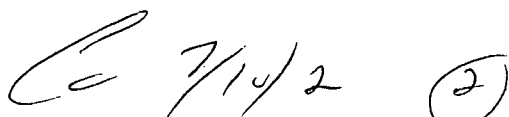
REMOVE KIT FROM D412-742-013

B 33563

B 33564

RE-STOCK AS K742 013

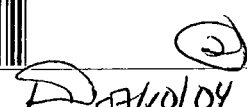
USING NEW B/N



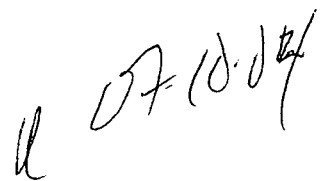
2.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE



Job Completion

31

Date: Monday, 7/16/2007 2:47:10 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT SKID ASSEMBLY
Job Number	: 33563A		
Estimate Number	: 10756	Part Number	: D412742043
P.O. Number	: <i>NIA</i>	Drawing Number	: D3391 REV F
This Issue	: 7/16/2007 S.O. No. : <i>NIA</i>	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: F
First Issue	: <i>NIA</i> Type : LANDING GEAR	Material	: <i>NIA</i>
Previous Run	: 33556A	Due Date	: 7/30/2007 Qty: 1 Um: Each
Written By	: <i>[Signature]</i>		
Checked & Approved By	: <i>[Signature]</i> 07.07.17		
Comment	: Est Rev A 05.10.13 New Issue KJ/JLM		
	: Est Rev B 06.02.13 ECN 773 dwg @ rev.D EC		
	: Est Rev C 07-05-28 As per Rev F JLM		

Additional Product

Job Number:



Seq. #	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

If D412-742-043 is a W/O on it's own,

Photocopy bluefile and create labels per PPP D412-742-043 CHG003

NIA
Approved with
W/O 33526

2.0	D3391023	Mid Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty	Part Number	Description	Batch
1	D3391-023	Mid Tube Assembly	<i>B32236</i>

3.0	D3391025	Aft Tube Assembly
-----	----------	-------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

Qty	Part Number	Description	Batch
1	D3391-025	Aft Tube Assembly	<i>B31856</i>

4.0	D35641	WEARSHOE
-----	--------	----------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: *33243* *07.07.28*

Date: Monday, 7/16/2007 2:47:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33563A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

(21)

Description :

5.0

D35643

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: ~~5328~~ / B33764 RT 07 07 28

6.0

D35645

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: 32730 RT 07 07 28

7.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: 33458 RT 07-07-28

8.0

D35665

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 33483 RT 07-07-28

9.0

AN3C4A

BOLT



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

BOLT

Batch: 104955 RT 07 07 28

10.0

AN3C6A

BOLT



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

BOLT

Batch: 103678 RT 07-07-28

11.0

AN3C7A

BOLT



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

Batch: 103668 RT 07 07 28

Date: Monday, 7/16/2007 2:47:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33563A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description:

12.0

AN960C10L

washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

washer

Batch: 107057

BT 07-07-28

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3

M105085

ML 07/07/24

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R Sikaflex-241/-291

104989

BT 07-07-28

Expiry date: 01-01-08

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

A/R LPS Procyon

M104251

A/R Sikaflex-241/-291

104989

BT 07-07-28

Expiry date:

08-01

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

ML 07/11/20

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/27/30

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

PPP 33526

07/11/30

Date: Monday, 7/16/2007 2:47:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT SKID ASSEMBLY

Job Number: 33563A

Part Number: D412742043

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC21

FINAL INSPECTION/W/O RELEASE



①

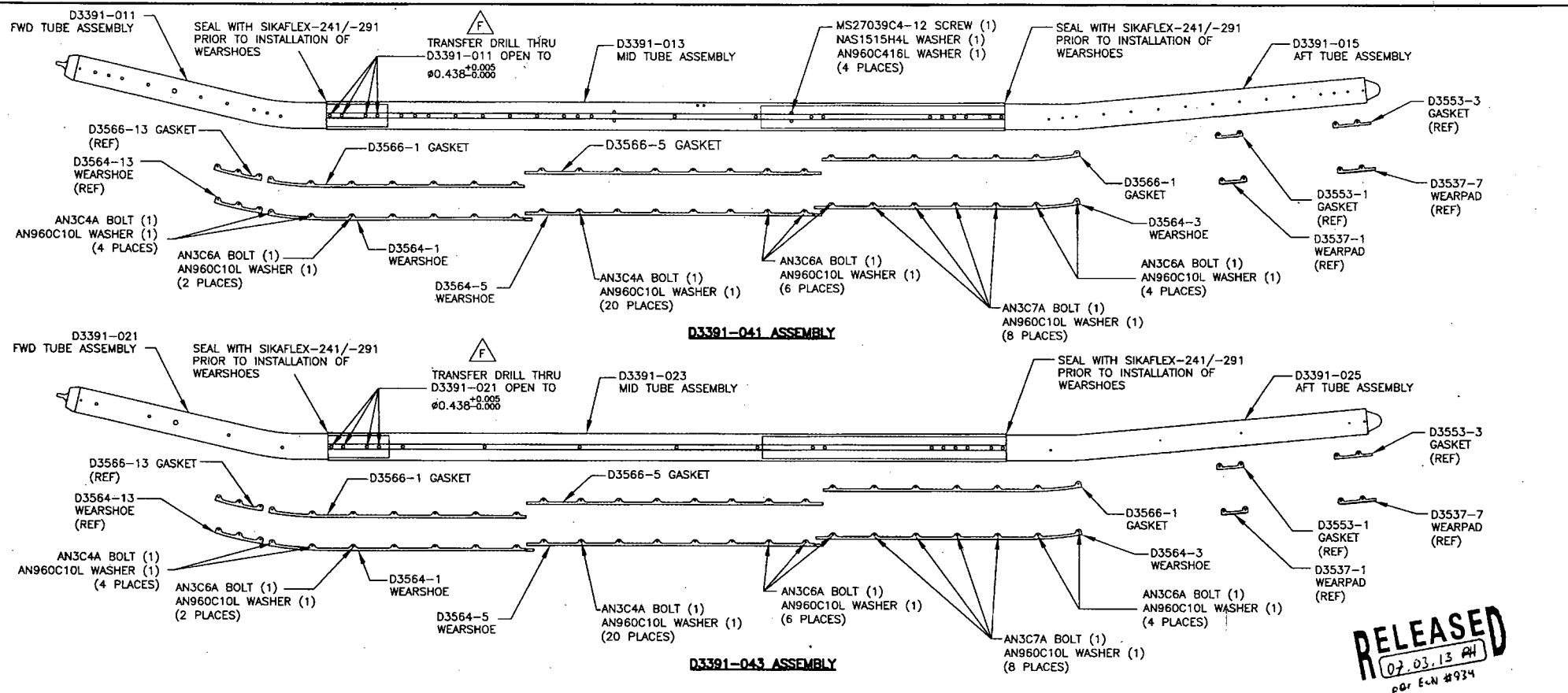
Comment: FINAL INSPECTION/W/O RELEASE

20710131

Job Completion



66 2-8-30



D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
1	1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	1	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	1	D3391-011	FWD TUBE ASSEMBLY
1	1	D3391-013	MID TUBE ASSEMBLY
1	1	D3391-015	AFT TUBE ASSEMBLY
1	1	D3391-021	FWD TUBE ASSEMBLY
1	1	D3391-023	MID TUBE ASSEMBLY
1	1	D3391-025	AFT TUBE ASSEMBLY
1	1	D3564-1	WEARSHOE
1	1	D3564-3	WEARSHOE
1	1	D3566-1	GASKET
1	1	D3566-5	GASKET
24	24	AN3C4A	BOLT
12	12	AN3C6A	BOLT
8	8	AN3C7A	BOLT
44	44	AN960C10L	WASHER
4	4	MS27039C4-12	SCREW
4	4	NAS1515H4L	WASHER
4	4	AN960C416L	WASHER

GENERAL NOTES

- 1) ALL DIMENSIONS ARE IN INCHES
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: ACID ETCH AND ALDINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 'E' SIZE HOLES (Ø0.250-Ø0.257) FOR WEARSHOE INSERTS. C'SINK Ø0.391/Ø0.425 x 100" AS APPLICABLE AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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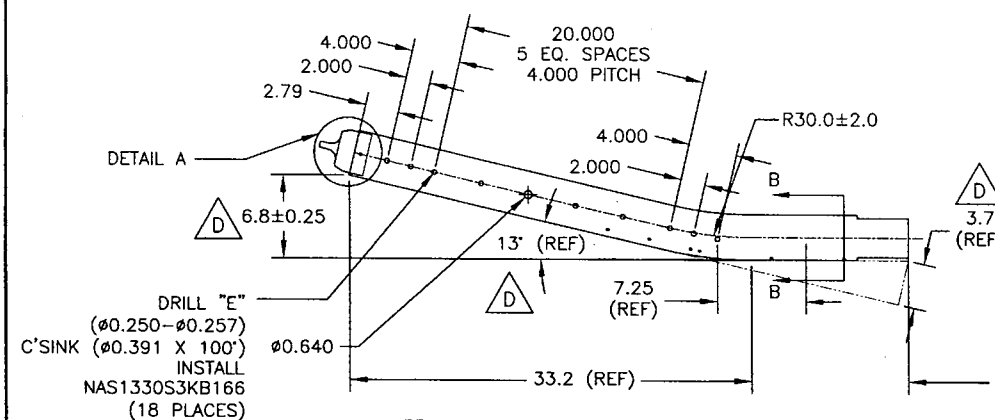
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

F	07.01.18	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021
E	06.04.25	CHANGE TOLERANCE, EASE MANUFACTURE
D	06.01.23	UPDATE TOLERANCE, CHANGE HOLE SIZE
C	05.09.27	LENGTHEN AFT EXTENSION
B	05.06.10	DRAWING UPDATES
A	05.02.07	NEW ISSUE
DESIGN	PH	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.01.18	TITLE
		412 FLOAT SKIDTUBE
		SCALE
		NTS

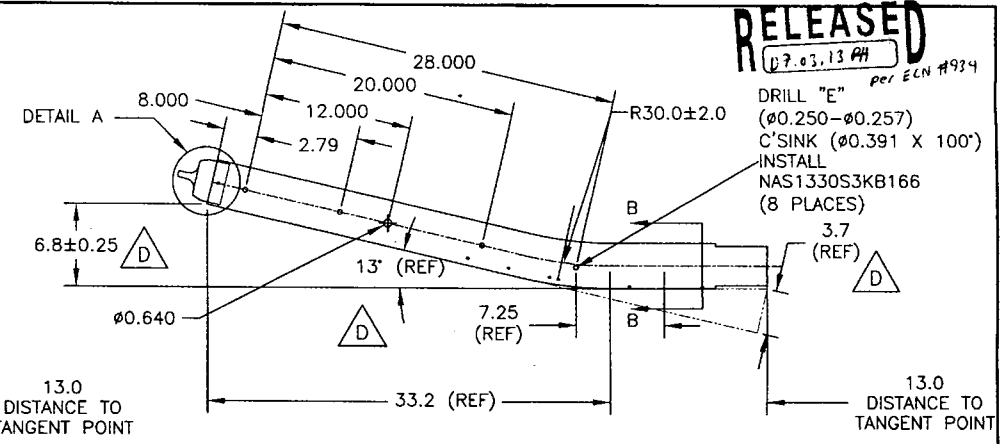
RELEASED
07.03.13 AH
per E.N. #934

NO WORK ORDER
35563A
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
CONTROLLED COPY
RETURN TO
SHOP COPY

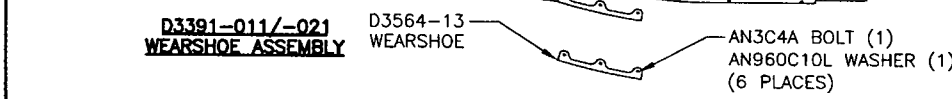
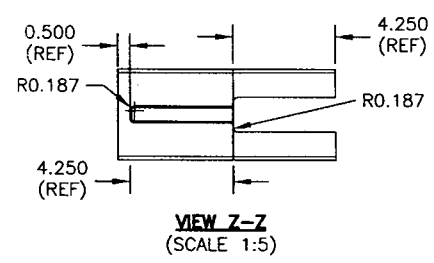
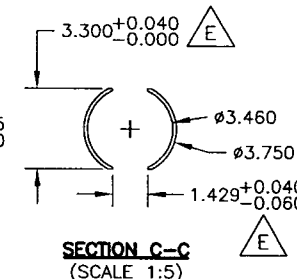
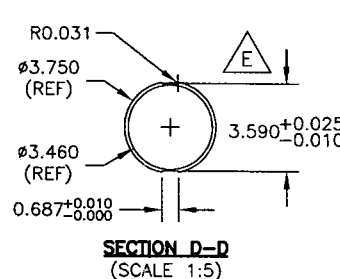
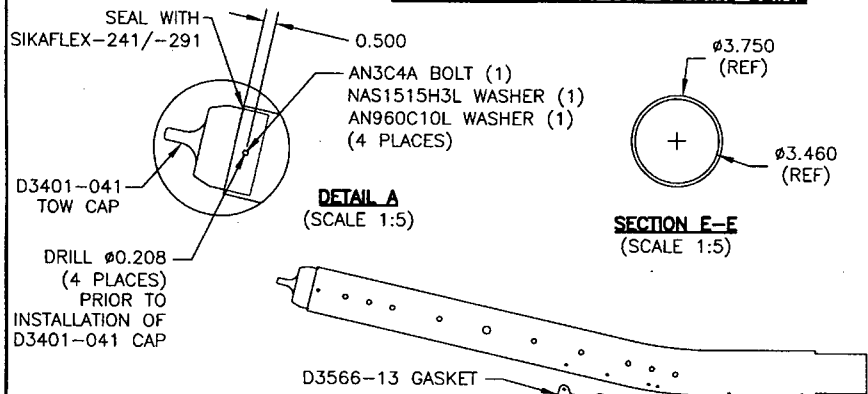
RELEASED
 P 7.03.13 RH
 per ECLN #934



D3391-011 ASSEMBLY AND BENDING DETAIL



D3391-021 ASSEMBLY AND BENDING DETAIL

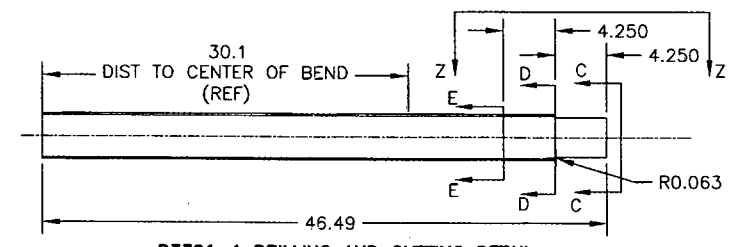
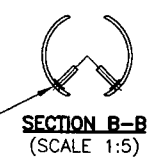


D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
10	10	AN3C4A	BOLT
4	4	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER
30	20	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)

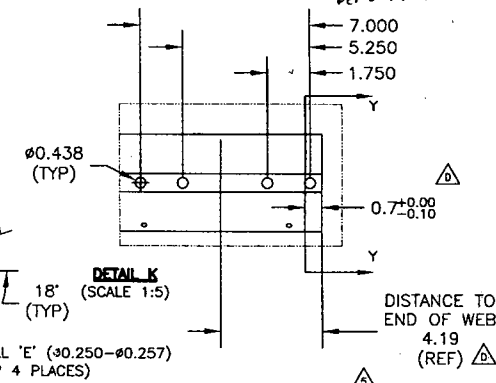
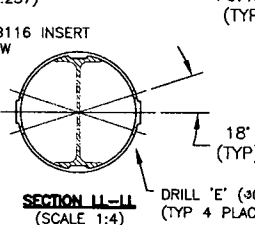
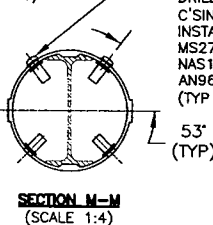
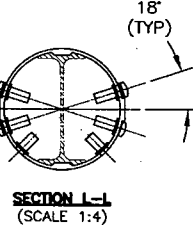
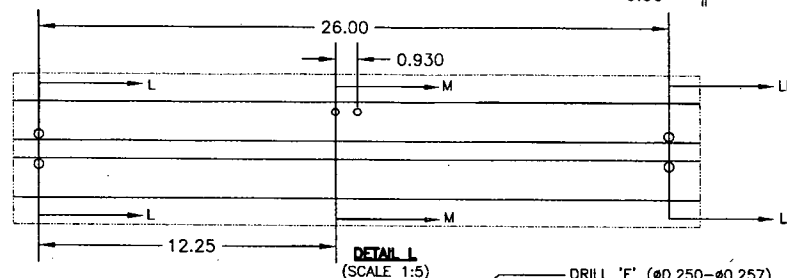
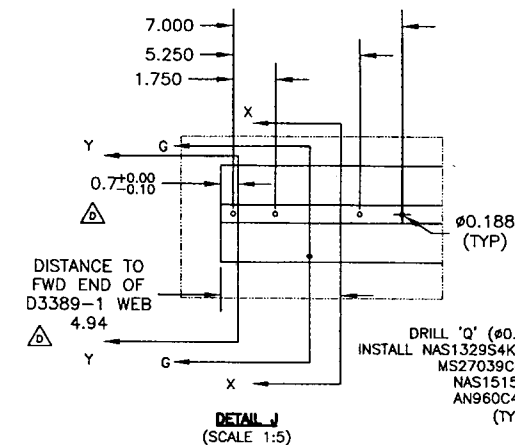
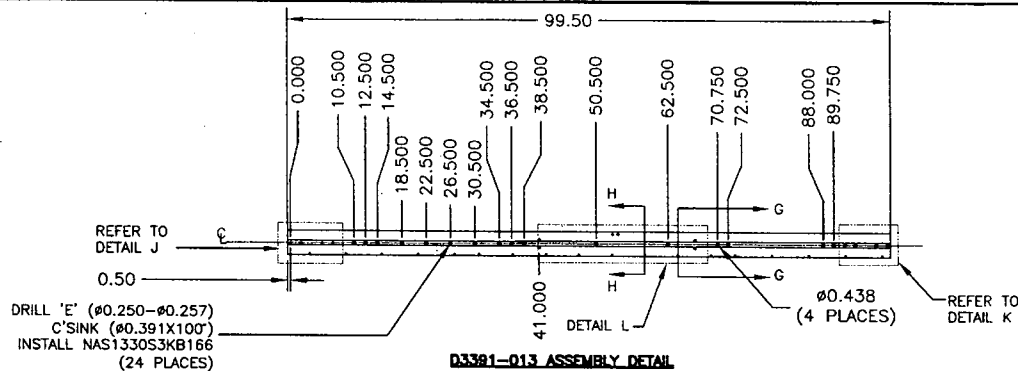
5
 DRILL "E"
 (Ø0.250-Ø0.257)
 C'SINK (Ø0.391 X 100")
 INSTALL
 NAS1330S3KB166
 (12 PLACES)

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D3391-1 DRILLING AND CUTTING DETAIL
 (MAKE FROM D6013-047 SKIDTUBE MATERIAL)

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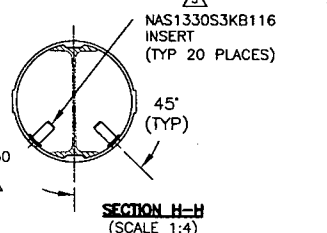
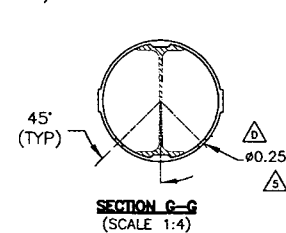
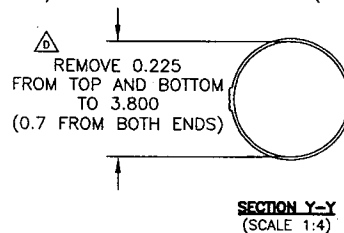
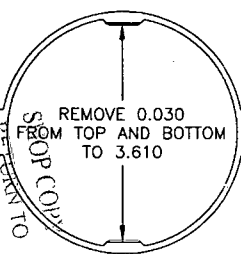
D3391-013/-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 013	QTY - 023	PART NUMBER	DESCRIPTION
X	X	D3391-013	MID TUBE ASSEMBLY
		D3391-023	MID TUBE ASSEMBLY
1	1	D2500-1-100	EXTRUSION
1	1	D3389-1	WEB
24	20	NAS1330S3KB116	INSERT (OR NAS1330C3KB116)
24	10	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1329S4KB140	INSERT (OR NAS1329C3KB140)
4		NAS1515H3L	WASHER
4		AN960C10L	WASHER
4		NAS1515H4L	WASHER
4		AN960C416L	WASHER
4		MS27039C1-09	SCREW
4		MS27039C4-08	SCREW

D3391-013/-023 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015

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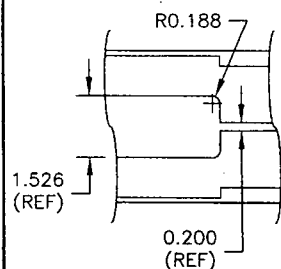
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DATE
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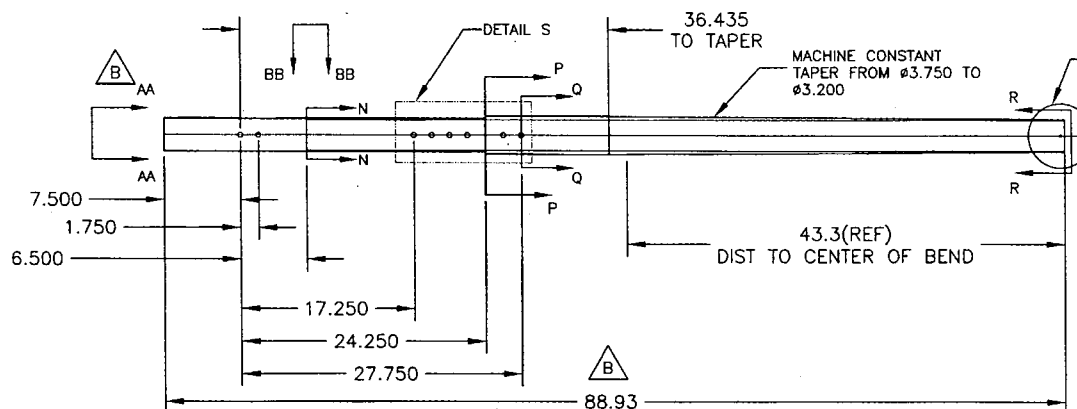
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D3391
TITLE
412 FLOAT SKIDTUBE
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1:20

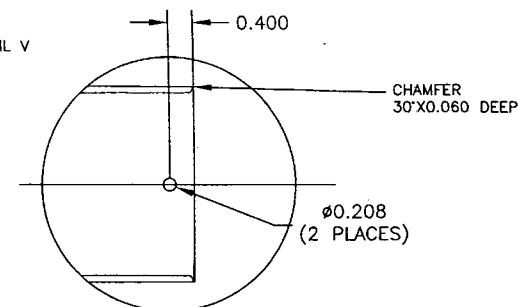
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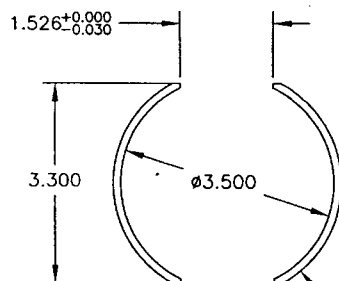
VIEW BB-BB
(SCALE 1:3)



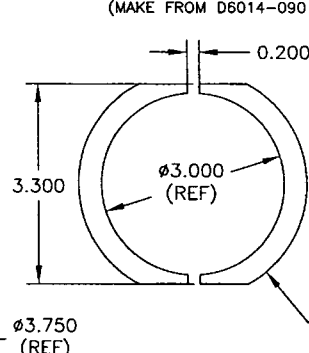
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)



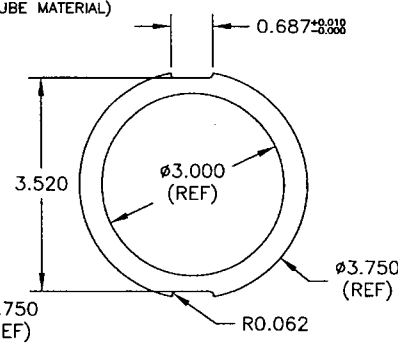
DETAIL V
(SCALE 1:2)



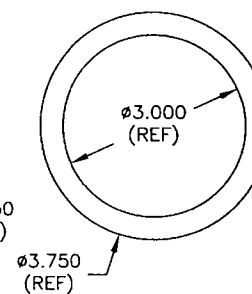
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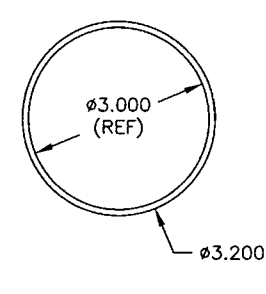
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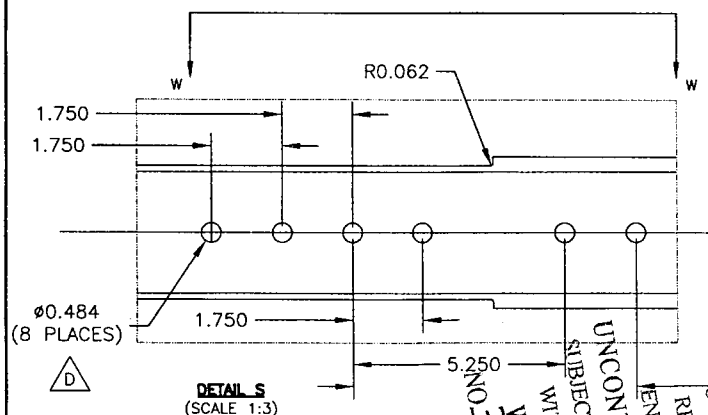
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(SCALE 1:2)



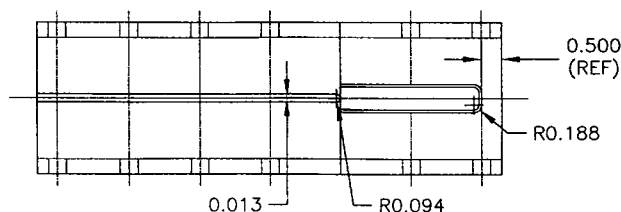
SECTION Q-Q
(SCALE 1:2)



SECTION R-R
(SCALE 1:2)



DETAIL S
(SCALE 1:3)



VIEW W-W
(SCALE 1:3)

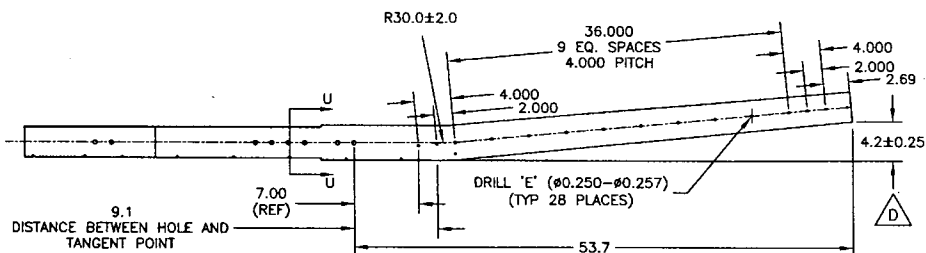
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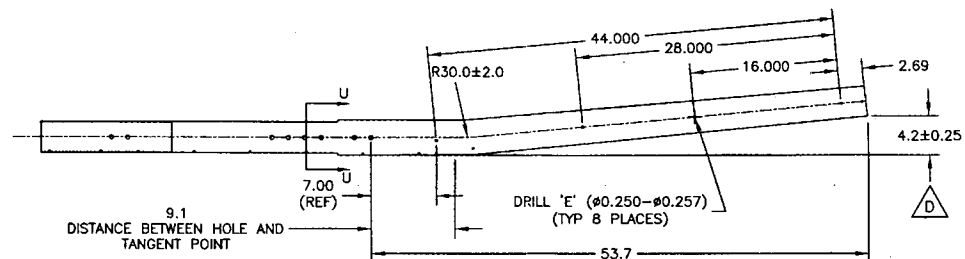
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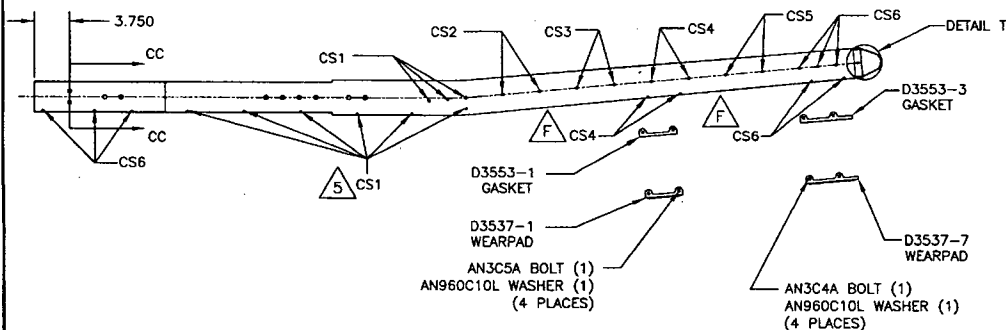
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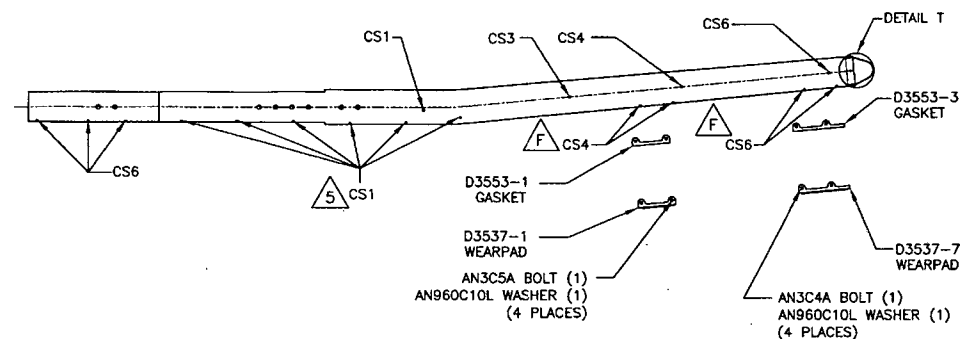
D3391-015 BENDING AND ASSEMBLY DETAIL



D3391-025 BENDING AND ASSEMBLY DETAIL



D3391-015 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

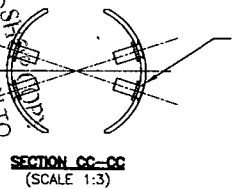


D3391-025 INSERT AND WEARPAD INSTALLATION DETAIL
(SEE TABLE)

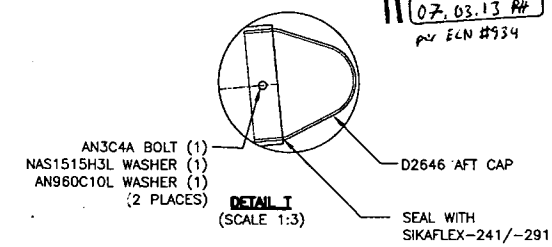
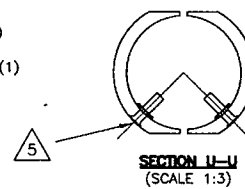
D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X	X	D3391-015	AFT TUBE ASSEMBLY
		D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
18	14	NAS1330S3KB366	INSERT (OR AES10KB366)
4	2	NAS1330S3KB316	INSERT (OR NAS1330C3KB316)
8	6	NAS1330S3KB266	INSERT (OR NAS1330C3KB266)
4		NAS1330S3KB216	INSERT (OR NAS1330C3KB216)
16	12	NAS1330S3KB166	INSERT (OR NAS1330C3KB166)
4		NAS1330S4KB151	INSERT (OR NAS1330C4KB151)
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
2	2	NAS1515H3L	WASHER
10	10	AN960C10L	WASHER

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DRILL 'Q' (#0.332-#0.338)
 C'SINK (#0.529X100")
 NAS1330S4KB151 INSERT (1)
 (4 PLACES)



C'SINK AND INSTALL NAS1330S3KBXXX IN HOLES MARKED CS1-CS6 AS FOLLOWS

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'SINK	P/N
CS1	18	14	Ø0.425	NAS1330S3KB366
CS2	4		Ø0.391	NAS1330S3KB366
CS3	4	2	Ø0.391	NAS1330S3KB316
CS4	8	6	Ø0.391	NAS1330S3KB266
CS5	4		Ø0.391	NAS1330S3KB216
CS6	16	12	Ø0.391	NAS1330S3KB166

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